

Work Order ID 84012

84012

Page 1

May-01-12 10:41:24 AM

Item ID: D2435

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 206

Start Date: 01/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/10 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2435	Rev E1
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(12)

120

0.00

120

FLOW WATER JET

B12-5-29

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

UHMW 1" Blk.

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

H/8

12-04-28

(x12)

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

12-04-28 (x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						12	0		
QC	Memo	0.00	B.A	12/06/30					
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging	2x 86 551 10x 86 337								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MF
12-07-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-01-12 10:41:31 AM

Page 1

Work Order ID: 84012

84012

Parent Item: D2435

D2435

Parent Item Name: Bearpaw, 206

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	231.2100	3.2	38.4			

MUHMWB10

UHMW 1" Black

**

1B12-5-29

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	199.6099947	
121277	12.8	
121278	186.809995	

121851

Dart Aerospace Ltd

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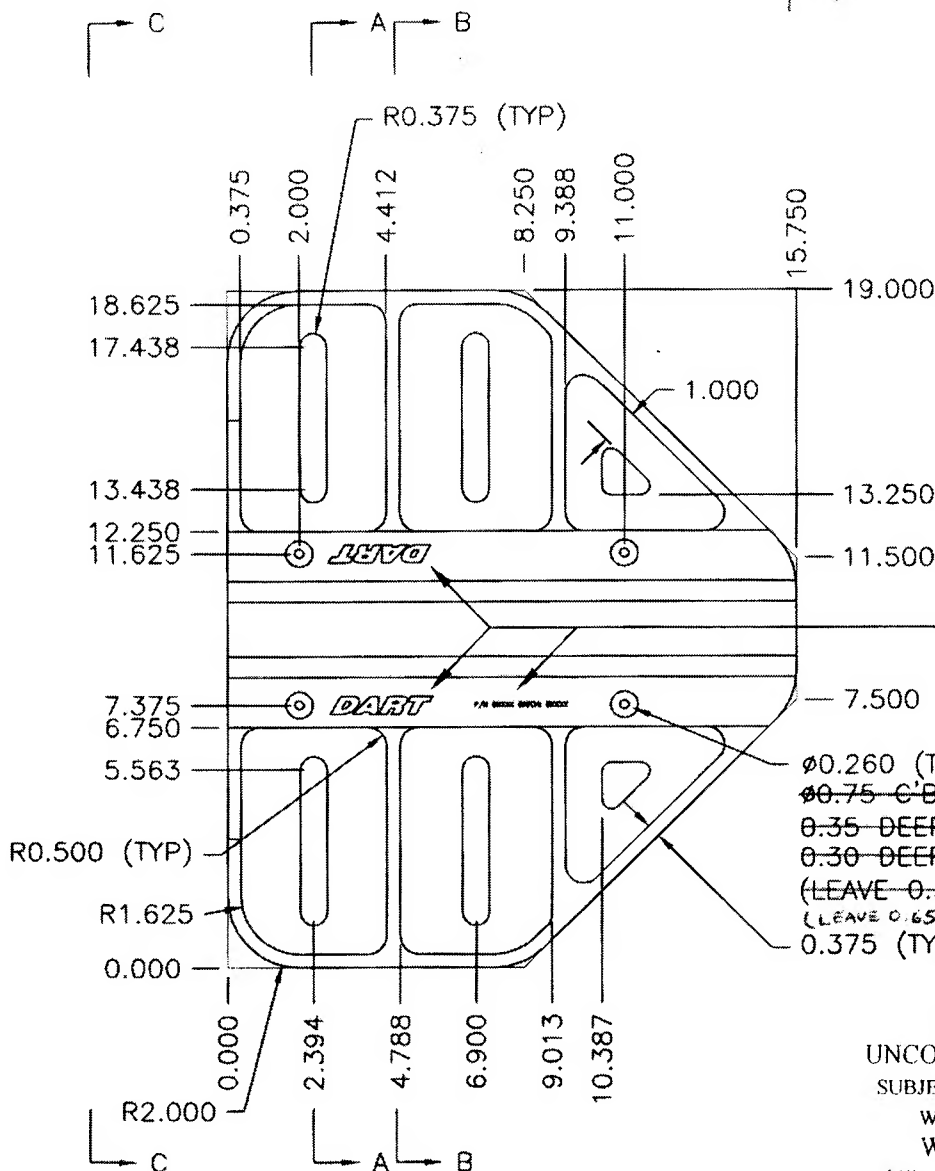
NOTE: Date & initial all entries



RELEASED
98.06.17 KE

DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. E
CHECKED KE	APPROVED KE	DRAWING NO. D2435
DATE 98.05.19	TITLE BEARPAW	SHEET 1 OF 2
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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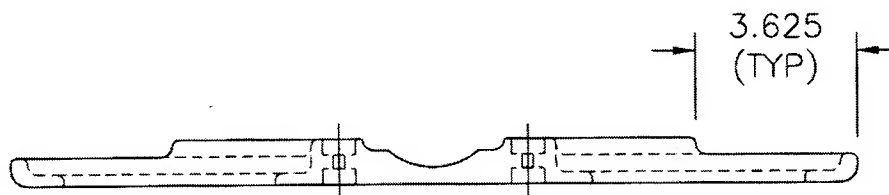
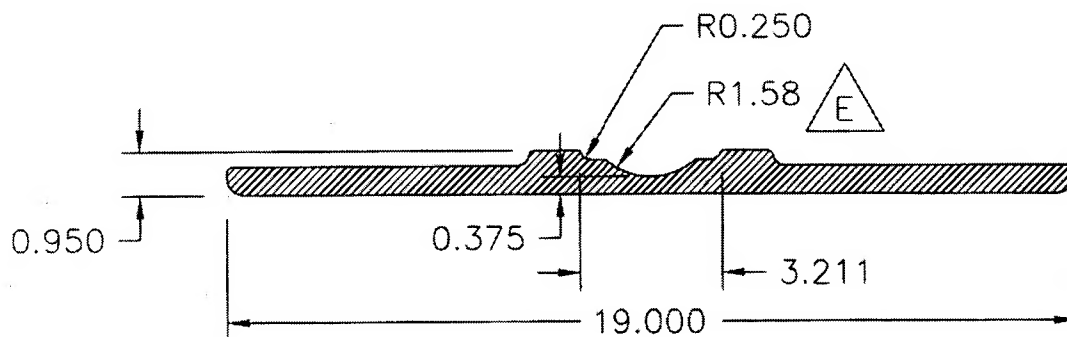
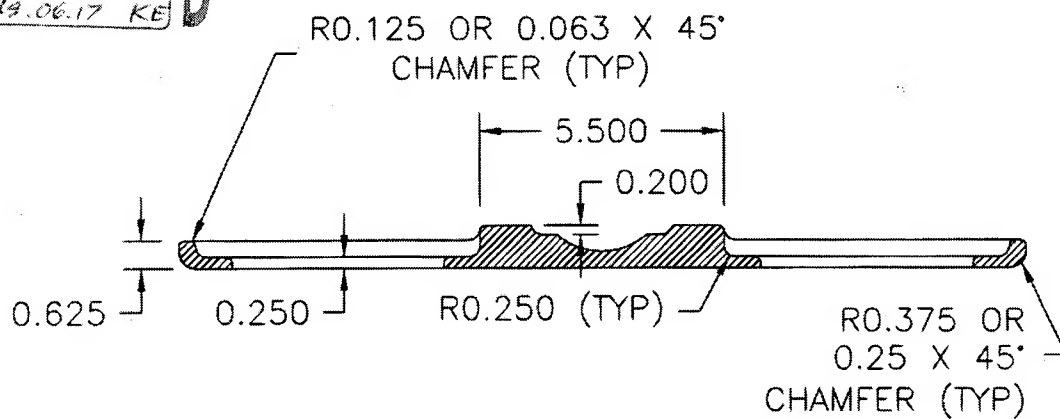
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED BW	APPROVED JS	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



84012

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DART AEROSPACE LTD		Work Order:	84012
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.083	✓		vern	RT-4
B	5.500	+/-0.030	5.503	✓		"	
C	0.200	+/-0.030	.194	✓		depth gauge	RT-6
D	R0.250	+/-0.030	.250	✓		rad gauge	
E	0.250	+/-0.010	.260	✓		vern	RT-4
F	0.625	+/-0.030	.640	✓		"	
G	0.25 x 45°	+/-0.030	.256	✓		"	
H	0.375	+/-0.010	.384	✓		"	
I	19.000	+/-0.030	19.000	✓		"	
J	0.950	+0.030/-0.010	.962	✓		"	
K	Ø0.260	+0.005/-0.000	.260	✓		"	
L	Ø0.930	+/-0.030	.926	✓		"	
M	0.30	+0.030/-0.000	.310	✓		depth gauge	RT-6
N	0.375	+/-0.030	.384	✓		vern	RT-4
O	7.375	+/-0.030	7.375	✓		"	
P	4.250	+/-0.010	4.253	✓		"	
Q	2.000	+/-0.030	2.016	✓		"	
R	9.000	+/-0.010	9.000	✓		Tape	RT-10
S	15.750	+/-0.030	15.750	✓		Tape	RT-10

Measured by: <u>RT</u>	Audited by: <u>B.A</u>	Prototype Approval:	N/A
Date: <u>02-06-24</u>	Date: <u>12/06/30</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <u>TF</u>	<u>TF</u>

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